

What is claimed is:

1. A toner including toner particles comprising:  
core particles formed by flocculating and fusion-bonding at least resin microparticles and colorant microparticles dispersed in fluid dispersion; and  
two or more coating layers formed over the core particles,  
wherein a wax is added to at least one of the coating layer(s) but for the outermost coating layer, and the core particles, and  
wherein a ratio  $d/r$  between an average thickness  $d$  of the overall coating layers and a volume average particle size  $r$  of the core particles is in the range of 0.01 to 0.6.
2. The toner as claimed in Claim 1, wherein a resin constituting said outermost coating layer has a glass transition point  $T_g$  of 55°C or more.
3. The toner as claimed in Claim 1, wherein a volume average particle size of said toner particles is in the range of 2 to 8  $\mu\text{m}$ .
4. The toner as claimed in Claim 1, wherein said resin microparticles comprise a resin containing a radical polymerizable monomer as a building block.

5. The toner as claimed in Claim 4, wherein said resin contains a radical polymerizable monomer having an acidic group in concentrations of 0.1 to 20 wt%.
6. The toner as claimed in Claim 1, wherein said ratio  $d/r$  is in the range of 0.01 to 0.1.
7. The toner as claimed in Claim 1, wherein at least one of said coating layers but for the outermost coating layer contains the wax.
8. The toner as claimed in Claim 1, wherein a content of the wax is 0.5 to 12 parts by weight based on 100 parts by weight of the resin contained in the toner particles.
9. The toner as claimed in Claim 2, wherein the resin constituting said outermost coating layer has a glass transition point  $T_g$  of 60°C or more.
10. The toner as claimed in Claim 1, wherein an average thickness  $d$  of said overall coating layers is in the range of 0.02 to 2.2  $\mu\text{m}$ .
11. The toner as claimed in Claim 10, wherein an average thickness  $d$  of said overall coating layers is in the range of 0.02 to 1  $\mu\text{m}$ .
12. The toner as claimed in Claim 1, wherein a volume average particle size of said toner particles is in the range of 2 to 5  $\mu\text{m}$ .
13. A toner production process comprising the steps of:

forming core particles by flocculating and fusion-bonding at least resin microparticles and colorant microparticles; and

forming two or more coating layers by flocculating and fusion-bonding resin microparticles to the surface of the core particles,

wherein a wax is added in at least one of the steps of forming said core particles and of forming the coating layer(s) but for the outermost coating layer, and

wherein a ratio  $d/r$  between an average thickness  $d$  of said overall coating layers and a volume average particle size  $r$  of the core particles is in the range of 0.01 to 0.6.

14. The toner production process as claimed in Claim 13, wherein the flocculation and fusion-bonding of said resin microparticles and colorant microparticles are carried out in a water-based medium at a temperature not lower than a glass transition point  $T_g$  of the resin microparticles.

15. The toner production process as claimed in Claim 13, wherein the formation of said coating layers is carried out in a water-based medium at a temperature not lower than a glass transition point  $T_g$  of the resin microparticles used in the coating layers.

16. The toner production process as claimed in Claim 13, wherein the step of forming said core particles uses a

nonionic surfactant for dispersing the resin microparticles and the colorant microparticles, the nonionic surfactant having a cloud point of not lower than a glass transition point  $T_g$  of the resin microparticles, and the flocculation and fusion-bonding of the microparticles are carried out at a temperature not lower than the cloud point of the nonionic surfactant.

17. The toner production process as claimed in claim 13, wherein the step of forming said coating layers uses a nonionic surfactant having a cloud point not lower than a glass transition point  $T_g$  of the resin microparticles used in the coating layers, and flocculates and fusion-bonds the resin microparticles to the surface of the core particles by heating the resin microparticles to a temperature not lower than the cloud point of the nonionic surfactant.

18. The toner production process as claimed in Claim 13, wherein the resin microparticles used for forming said coating layers have a volume average particle size of 80 to 200 nm.

19. The toner production process as claimed in Claim 18, wherein the resin microparticles used for forming said coating layers have a volume average particle size of 100 to 150 nm.

20. The toner production process as claimed in Claim 13, wherein the resin microparticles used for forming said core

particles have a volume average particle size of 80 to 200 nm.